

Date: Tuesday, 5/23/2006 8:32:05 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG BRACKET
Job Number	: 27197		
Estimate Number	: 11679		
P.O. Number	: N/A	Part Number	: D30463
This Issue	: 5/23/2006 S.O. No. : N/A	Drawing Number	: D3046 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL / MED FAB	Drawing Revision	: A
Previous Run	: 25385	Material	: N/A
Written By	: <u>SKA COMMENT Below</u>	Due Date	: 6/2/2006
Checked & Approved By	: <u>9/06 05.23</u>	Qty:	<u>16</u> Um: Each
Comment	: Est Rev: New Issue 06-01-04 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue Return Authorization #: R487Bell Original Batch #: 8x A6302, 2x D2789, 2x A6345, 3x U8388, 1x D2806Bell Original Part #: 206-052-106-1

2.0	D30463P	Lug Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 13.0000 Each(s)
 Lug Bracket

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

4.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Level 2 inspection

Job Completion

W 06.05.26DL 06/05/241.1 Powder Coat Moss white.1.2 QC3.SB 06/05/24 16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/05/26

NOTE: Date & initial all entries

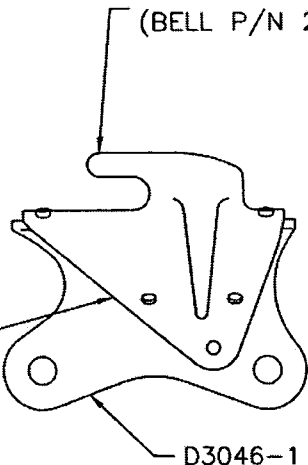
QA: N/C Closed: _____ Date: _____

DART



DESIGN		DRAWN BY		DART AEROSPACE LTD	
CHECKED		APPROVED		DRAWING NO.	
DATE		TITLE		SHEET 1 OF 2	
01.08.23		LUG BRACKET		SCALE	
A		01.08.23		NEW ISSUE	

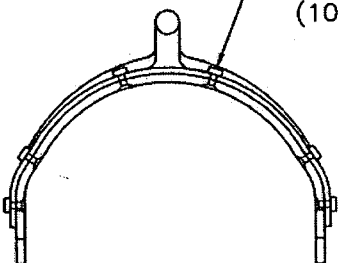
D3046-3
(BELL P/N 206-052-106-1)



D3046-1

CENTER D3046-3
ON D3046-1

TRANSFER DRILL $\varnothing 0.156$ HOLES
FROM D3046-3 TO D3046-1.
C'SINK $\varnothing 0.286 \times 100^\circ$
D3046-1 INSIDE BORE.
ASSEMBLE USING MS20426AD5-7
RIVETS.
(10 PLACES)



D3046-041 LUG BRACKET ASSEMBLY

NOTES:

- 1) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
POWDER COAT BOTH PARTS SEPARATELY BEFORE ASSEMBLY.
RE-POWDER AFTER ASSEMBLY.
REMOVE ALL PAINT/SEALANT FROM D3046-3 BEFORE POWDER COATING.

RELEASED
9.08.27

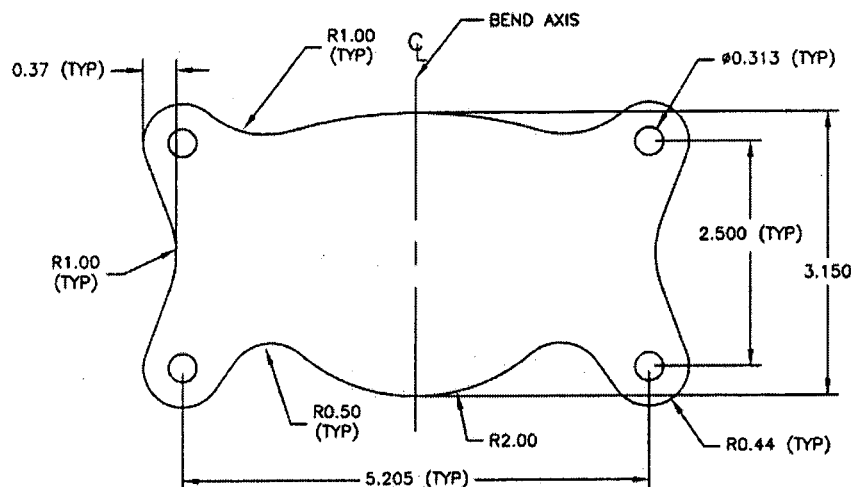
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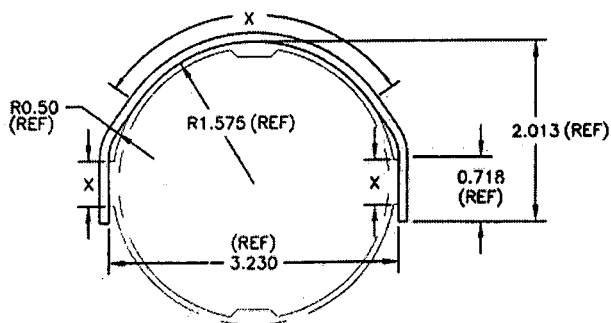
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DESIGN #	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3046	REV. A SHEET 2 OF 2
DATE 01.08.23		TITLE LUG BRACKET	SCALE 1:2



D3046-11 FLAT PATTERN
SYMMETRICAL ABOUT CENTRE-LINES (C)



D3046-1
(MAKE FROM D3046-11)

D3046-1 SHOULD BE BENT SO THAT IT IS WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2600-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL 0.100 THICK (12 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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